

# Work Order ID 86997

July-09-12 9:29:07 AM

**\*86997\***

Page 1

Item ID: D4019-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Light Lid Short Basket Assembly  
 Start Date: 7/09/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: [Signature] Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4019	D

100 Weld per dwg A/R Aluminum rod Batch: M120354 0.00  
**\*100\*** Large Fab 1x PL 12-07-09  
 Memo 0.00

1- Assemble ribs, weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D4019

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\*** QC 1 0 BE 12-07-09  
 Memo 0.00  
 Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86997

**\*86997\***

Page 2

July-09-12 9:29:07 AM

Item ID: D4019-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/10/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch 012854	0.00							
<b>*140*</b>									
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

*Handwritten notes:*  
 1 NG 12-7-9  
 Cpl / CC 12 - 7 - 10

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 86997

\*86997\*

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Item ID: D4019-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Light Lid Short Basket Assembly  
 Start Date: 7/09/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/10/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*150*									
QC									
Quality Control	5 QCS	78							12/07/10
	Memo	0.00							
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*160*									
Powdercoat									
Powder Coating	Memo	0.00							
	1- touch up corner with alodine only								
	2- Plug holes prior to and mask sides of hinge prior to powdercoat								

1ST COAT: 8:45  
 START TIME: 3200 F  
 OVEN TEMPERATURE: 3200 F  
 FINISH TIME: 9:15  
 \*\*\*\*\* 2nd coat if necessary \*\*\*\*\*  
 2ND COAT:  
 START TIME: \_\_\_\_\_  
 OVEN TEMPERATURE: \_\_\_\_\_  
 FINISH TIME: \_\_\_\_\_

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries



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July-09-12 9:29:07 AM

**Item ID:** D4019-041

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Light Lid Short Basket Assembly

Stop \*NS2\*

**Start Date:** 7/09/12      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date:** 7/10/12      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

200

Identify as per dwg & Stock Location: D-1052 213

85738

**\*200\***

### Packaging

## Memo

0.00

## Packaging

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

## Memo

0.00

## Quality Control

1  $\phi$  BR 12-7-10

MLJ 12/07/11

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.07 verified by:EC  
verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC  
as per dwg revD DD 10.08.18 verified by:EC IPP Rev:B as per dwg revA 10.03.15  
IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4019-1 Rib		Manufactured	No			100	Each	2.0000	2	2		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		2							
				60974		2							
✓ D4019-3 Rib		Manufactured	No			100	Each	14.0000	2	2		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
				63667		0							
				83798		2							
				84848		4							
				86449		8							
✓ D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	9.0000	3	3		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		9							
				85937		9							
✓ D2957 Mounting Plate		Manufactured	No			100	Each	10.0000	4	4		lpc 12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				84820		10							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

July-09-12 9:29:07 AM

Page 2

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-045 Manufactured No 100 Each 5.0000 1 1 Pl 12.07.09  
Lid Rib Assembly, Fwd (Light)

Location	Loc Qty	Loc Code
WA	5	
63668	0	
74466	1	
84688	4	

✓ D4035-047 Manufactured No 100 Each 4.0000 1 1 Pl 12.07.09  
Lid Rib Assembly, Aft (Light)

Location	Loc Qty	Loc Code
WA	4	
63669	0	
85936	4	

✓ D4029-043 Manufactured No 180 Each 5.0000 1 1 - JB  
Webbing (Short Basket)

Location	Loc Qty	Loc Code
st503	5	
56967	5	

✓ D4056-1 Manufactured No 100 Each 2.0000 1 1 Pl 12.07.09  
Label Plate

Location	Loc Qty	Loc Code
WA005	2	
84866	2	

NAS1149DN416J Purchased No 180 Each 474.0000 30 30 ✓ JB 12/07/10  
Washer

Location	Loc Qty	Loc Code
ST297	474	
114597	43	
122151	400	
13910	31	

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Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

July-09-12 9:29:07 AM

Page 3

Work Order ID: 86997

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 7/09/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,284.0000

30

30

Cherry Rivets

Location

Loc Qty

Loc Code

ST314

560

122151

560

ST321

591

111636

36

117601

3

118626

294

120308

258

WA018

133

107939

133

D2728-1

Manufactured

No

180

Each

0.0000

1

1

Dart Logo label

July-09-12 9:29:07 AM

Shop Packet Print

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

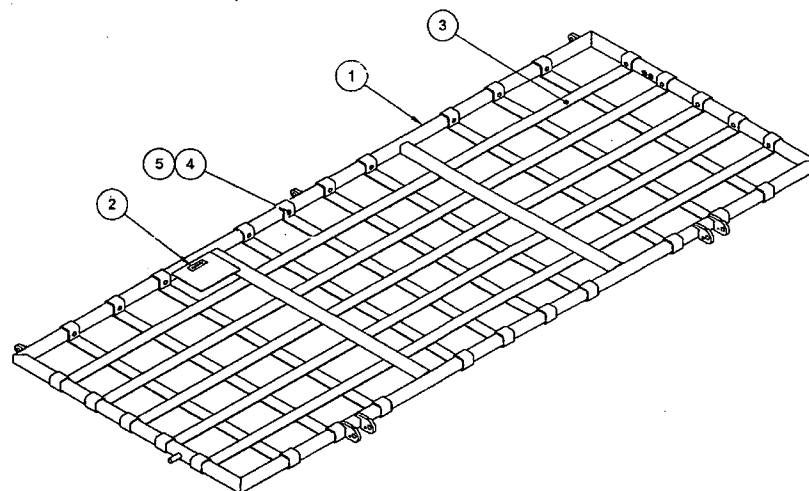
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



**D4019-041 LIGHT LID SHORT BASKET ASSY**

**RELEASED**  
10.08.12  
ECN 10-596

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.83 lbs

D	REORGANIZED BILL OF MATERIALS; SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-243, UPDATED VIEW E ACCORDINGLY (A7-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5; BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2); SECTION B-B REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALIS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	2		
CHECKED	JSC	DRAWING NO.	REV. D
MFG. APPR.	JSC	D4019	SHEET 1 OF 4
APPROVED	JSC	TITLE	SCALE
DE APPR.	JSC	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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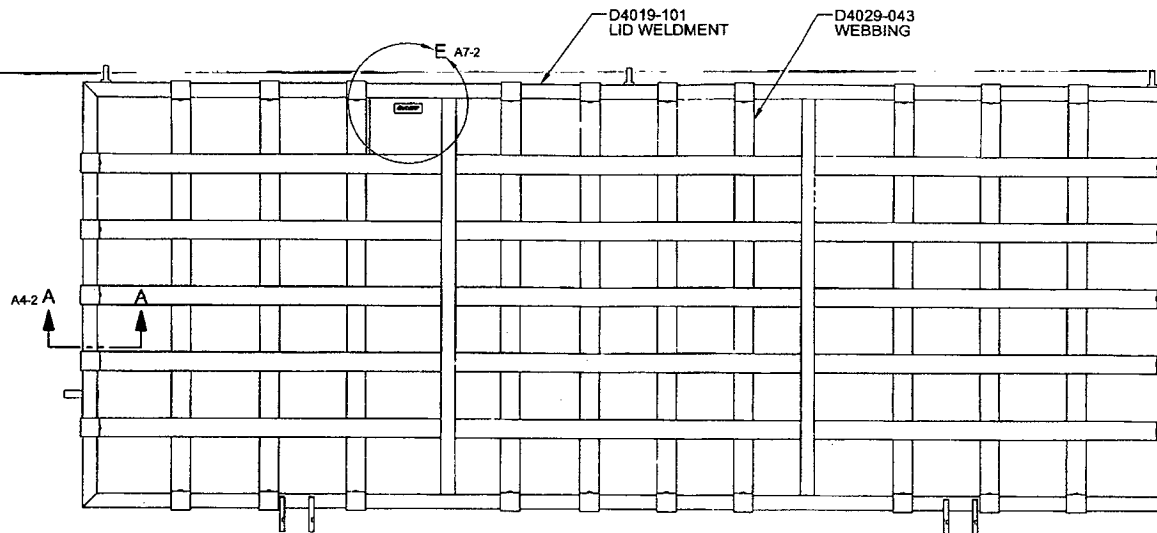
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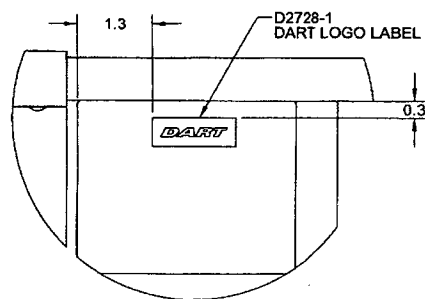
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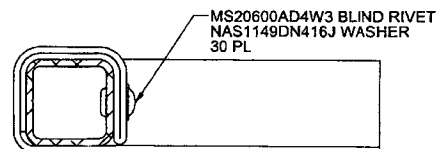
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**D4019-041 LIGHT LID SHORT BASKET ASSY**



**DETAIL E D5-2**



**SECTION A-A C7-2**

**RELEASED**  
10.08.12 CP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. <b>D4019</b>	REV. D
MFG. APPR.	MP	SHEET 2 OF 4	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	<b>LIGHT LID SHORT BASKET</b>	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

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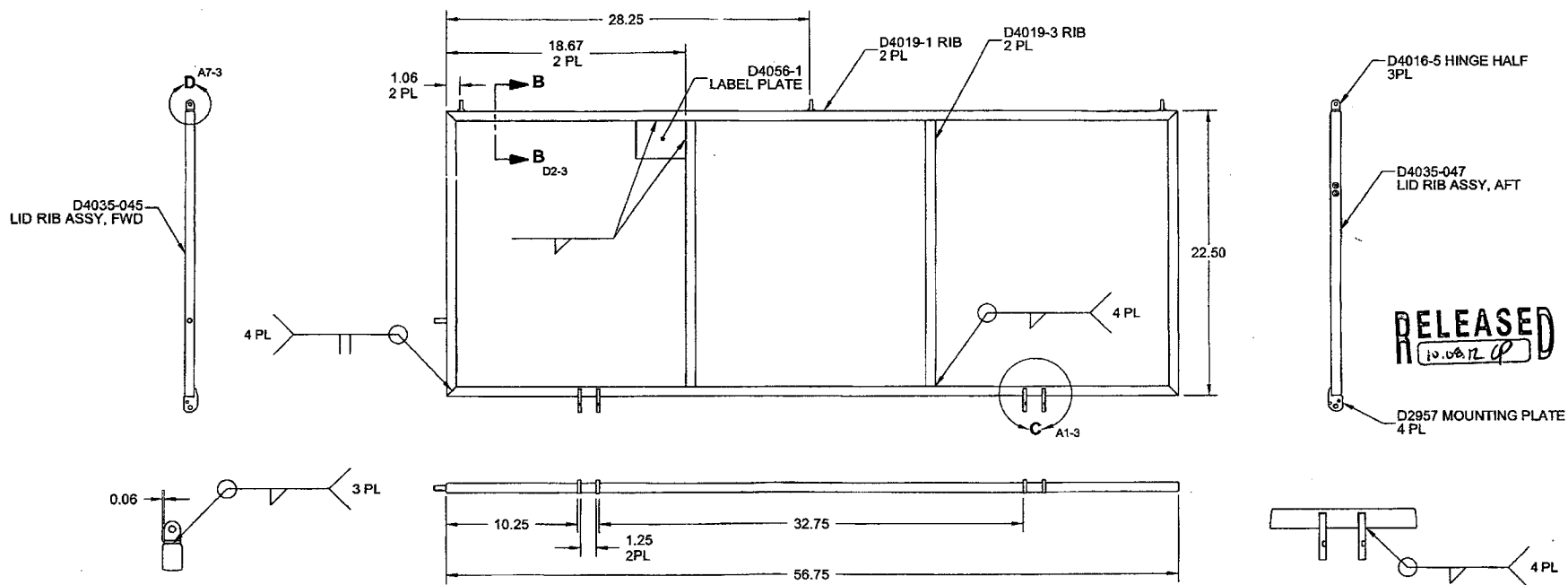
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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ITEM	QTY	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET

# SECTION B-B C6-3



DETAIL D C7-3

D4019-101 BASKET LID WELDMENT ASSY

DETAIL C C3-3

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	AKS	D4019	SHEET 3 OF 4
APPROVED	AKS	TITLE	SCALE
DE APPR.	AKS	LIGHT LID SHORT BASKET	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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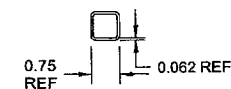
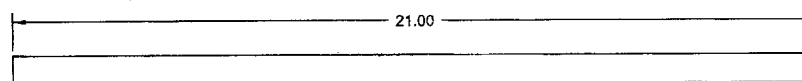
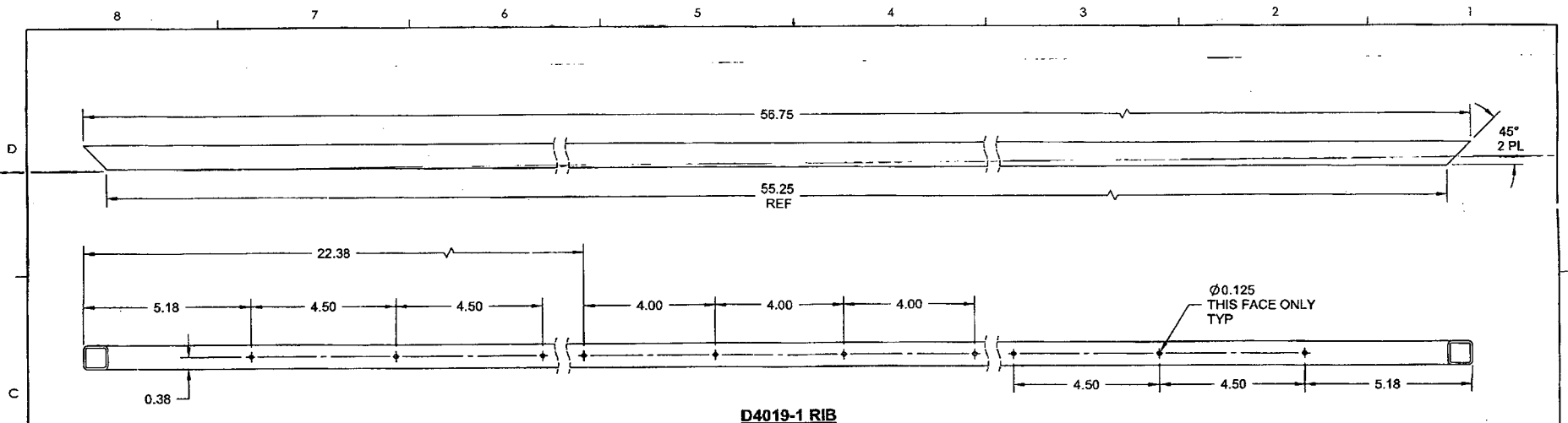
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
10.08.12

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 0.77 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D4019	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries